

Work Order ID 102525

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ASAP
102525

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Item ID: D3537-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/28/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/07/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: *W* Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								
<i>304.063</i>									<i>12</i> <i>φ</i> <i>Ac/Im</i> <i>13.06.02</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									<i>12</i> <i>φ</i> <i>Ac/Im</i> <i>13.06.02</i>
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									<i>12</i> <i>φ</i> <i>Ac/Im</i> <i>13.06.02</i>

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Item ID: D3537-7 Accept *N900040100* Setup Start *NS1*
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 Item Name: Wearpad
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 Required Date: 6/07/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				12			SP 13/06/04
130	Brake NC	0.00							
Brake NC	Memo								
	Debur if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.								
140	QC5- Inspect part completeness to step on W/O	0.00				10			
140	QC	0.00							
Quality Control	Memo								
	Ensure joggle as per dwg D3429								
150	Large Fab	0.00				12			13-06-04
150	Large Fab	0.00							
Large Fab	Memo								
	Qty Description Batch A/R 2059B Hardcoat								
	M125126 Weld hardcoat as per Dwg D3437								

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 Required Date: 6/07/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				10			
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170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10			
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180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: FINISH TIME: OVEN TEMPERATURE:	0.00 0.00							
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ml21279

3:40
320°F 4:10

12 X 8 m / 13/06/06

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Cust Item ID:

Required Date: 6/07/13 Req'd Qty: 12.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12x d Ill 13/06/07

12x d Ill 13/06/07

13/6/10

13-06-11

Picklist Print

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Work Order ID: 102525

Parent Item: D3537-7

Parent Item Name: Wearpad

Start Date: 5/28/13

Required Date: 6/07/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-12 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA
304/316 Sheet .063

Purchased

No

100

sf

446.0842

0.15

1.8947368

1.9

Ac 1 gm.

13.06.02

Location

Loc Qty

Loc Code

MAT020

446.0841688

122245

0.1713688

123136

140.8

124428

23.61

124572

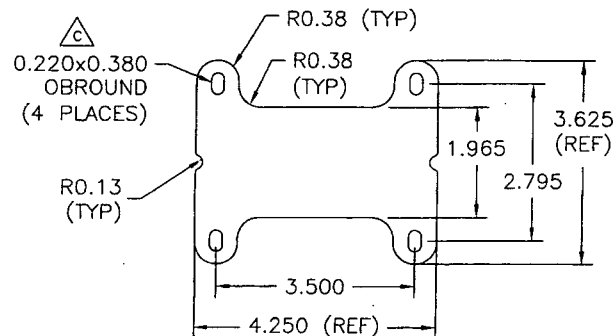
25.5028

125599

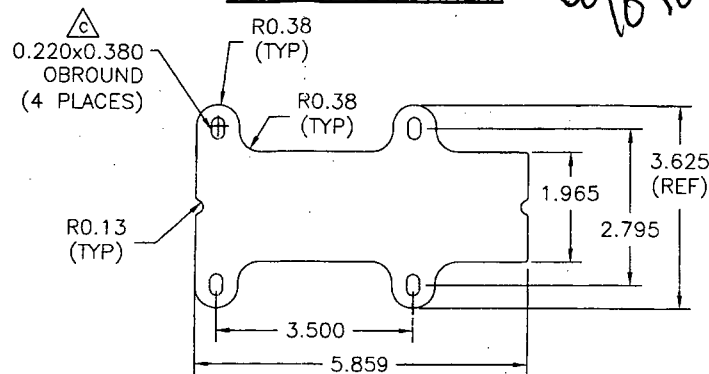
256

125599

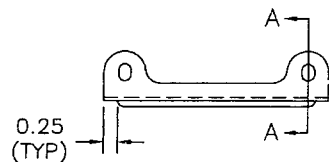
D3537-1F FLAT PATTERN



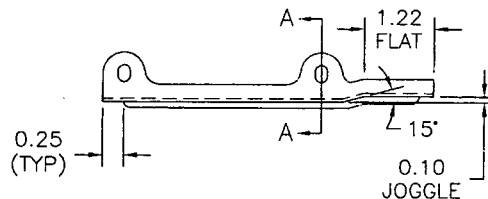
D3537-3F FLAT PATTERN



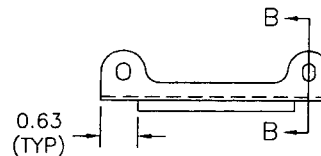
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



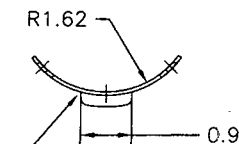
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

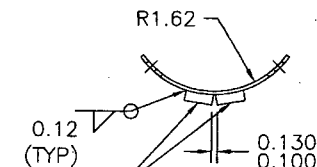
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

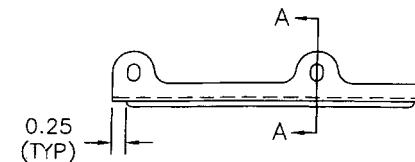
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-08 PM
PER ECU
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET: 1 OF 1
		SCALE 1:2

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